

Work Order ID 52893

October 19, 2009 10:37:54 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 10/19/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/27/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

PL

Date: 09/10/19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2512	Rev E								

100	Weld per dwg A/R S.S. rod Batch: M10923	0.00
-----	---	------



Large Fab	Memo	0.00
-----------	------	------

Large Fab	1-Cut 3/4" x 3/4" square tubing as per Dwg D2512	
	2-Cut (4) D2236 From D3166-3	
	3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305	
	4-Weld as per Dwg D2512 using Welding Jig DT 9436	
	Deburr as required	
	INSTALL D2012-117 CLEVIS ONLY ON D130-701-041	

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------



QC	Memo	0.00
----	------	------

Quality Control

PL →

PL

09.11.02
09.0

PL 09 11 03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-11-18	100	Add step to shear mesh to size, as not mentioned in Memo. * See NCR below. Perm change <i>/</i>				<i>/</i> 09-11-18	<i>/</i> 09-11-18

Part No: D2512 PAR #: _____ Fault Category: Lower Sals NCR: Yes No DQA: / Date: 09-11-18
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: / Date: 09-11-18

NCR: 52893		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-11-18	100	During welding found that mesh for lid was cut ^{sheared} crooked crooked from in w/ht from one end to the other.	<i>/</i> 09/11/18	Scrap and Destroy mesh. → was all ready taken into part when problem was found - Replace M# <u>112311</u>	<u>SAD</u> 09/10/02 <u>P</u>	<u>S</u> 09/10/04	<i>/</i> 09/10/18	<i>/</i> 09/10/18
		R.C. employee who steal cut the mesh cut it crooked. Employee went all wrong inc LQA. (SAD)	<i>/</i> 09/11/18	Not	09.11.02		<i>/</i> 09/10/18	<i>/</i> 09/10/18

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC6- Inspect dimensions to drawing

Set Up/
Run Hours

0.00

Draw
Number

→ Solu04

Draw
Rev.

0.00

Plan
Code

0.00

Accept
Qty

0.00

Reject
Qty

0.00

Reject
Number

0.00

Insp.
Stamp

130



Powdercoat

Powder Coating

* PRESSURE - WASH
White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum
M112148

0.00

→ 11/09/11/09

0.00

→ 11/09/11/09

Memo

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 2:15pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:45pm

2ND COAT:

START TIME: 3:10pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:40pm

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Stop



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Start Date: 10/19/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/27/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

140



HandFinish

**Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

M112437

0.00

=> M1 09/11/05 (X1) Ø

Hand Finishing

Memo

0.00

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4
Batch: M112106

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

MWD 09/11/05

X1

Memo

0.00

160



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

PPP

Memo

0.00

52893 09/11/05

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Stop



Item Name: Basket Lid 205/350

Start Date: 10/19/09 Start Qty: 1.00



Cust Item ID:

Required Date: 10/27/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**

170

QC21- Final Inspection - Work Order Release



QC

Quality Control

**Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

0.00

0.00

09/11/10 HJ

Memo

MF
09-11-10

Picklist Print

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Page 1

Work Order ID: 52893



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2012-117RevC		Manufactured	No			100	Each	28.0000	2.0000			

Clevis

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	28
31101	2
52498	26

PD 09.10.29

ONLY APPLICABLE ON D130-701-01

D2232-1RevC

Manufactured No

100 Each 30.0000 2.0000



Basket Hinge

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	2
48230	2

Main Warehouse

WA	28
50896	8
51105	20

PD 09.10.29

Picklist Print

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Page 2

Work Order ID: 52893



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1RevD		Manufactured	No			100	Each	45.0000	2.0000			

Spacer Bushing

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	45	
51331	20	
52832	25	

PD 09.11.02

D2506RevF



Manufactured No

100 Each 6.0000 1.0000



Label Plate

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	2	
44275	1	
51135	1	

Main Warehouse

WA	4	
51303	4	

52834 PD 09.11.02

Picklist Print

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Work Order ID: 52893



Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	74.0000	2.0000			

Mounting Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	13
46086	2
48428	1
51120	10

Main Warehouse

WA	61
50872	12
51745	49

PD 09.10.29

D3166-3RevA1



Manufactured

No

100

Each

13.6210 1.0000



Basket Hoop

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA	13.621
50033	0.0527
50618	1.5683
51249	6
52058	6

PD 09.10.28

Picklist Print

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Parent Item: D2512RevE



Parent Item Name: Basket Lid 205/350

Start Date: 10/19/09

Required Date: 10/27/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304EX0.75-16F

Purchased

No

100

sf

201.0648

18.9474

Expanded Metal Flat SS

SAD

09-10-22

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

MAT	201.0648065	
110134	6.7	
111630	9.15	
111956	0.000017	
112147	8.29428947	
112311	28.9205	
112707	148	

M304TS0.750W.065

Purchased

No

100

f

561.0601

45.8741

304 SQ Tube .75x.75x.065W

Warehouse	Loc Qty	Loc Code
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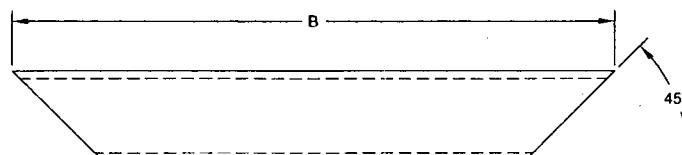
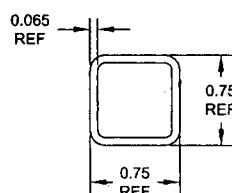
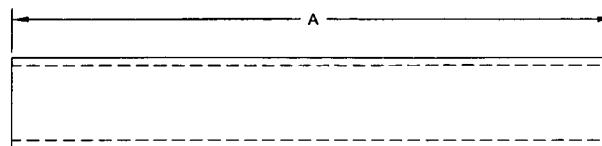
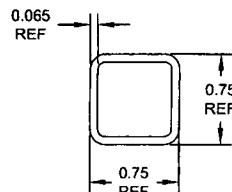
Location

Main Warehouse

WA	561.0601	
112398	561.0601	

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

D2512-1/3/5/7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065'
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

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NO. 50893
PL 09-10-19

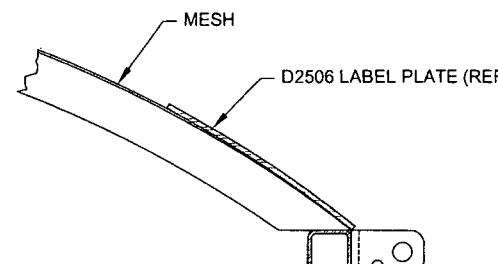
RELEASED
08-21-17

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2512	
MFG. APPR.		REV. E SHEET 1 OF 4	
APPROVED		TITLE BASKET LID ASSEMBLY (350/212)	
DE APPR.		SCALE NTS	
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED IN THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THE COPIED TO ANY OTHER PERSON OR ENTITY WITHOUT PRIOR WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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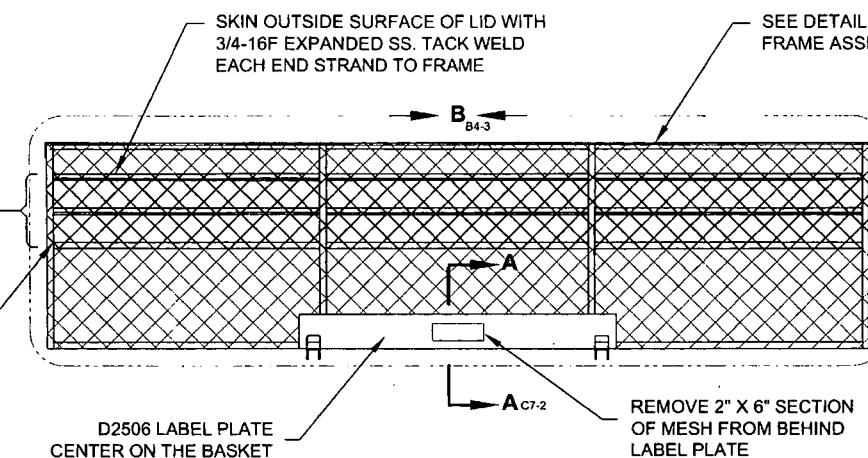
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WORK CENTER
NO. 52893



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

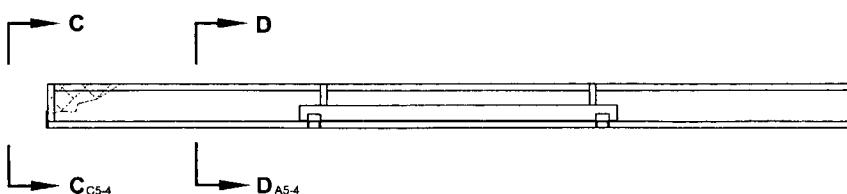
TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



E

D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



RELEASED
(05-05-21/11)

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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